

Date: Thursday, 23/10/2008 10:54:04 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 42885
 Estimate Number : 12930
 P.O. Number :
 This Issue : 23/10/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1 Type : MACHINED PARTS
 Previous Run : 41725
 Written By :
 Checked & Approved By : JLD 08.10.24
 Comment : Est Rev:A New Issue 07-07-04 JLM

Drawing Name : 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE
 Part Number : D2932ZUP **D2933-2UP**
 Drawing Number : D2932 REV C
 Project Number : N/A **D2933** *Jan 08 11-11*
 Drawing Revision : C
 Material :
 Due Date : 15/11/2008 Qty: 8 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101003 *08/11/11* Saddle Billet, 7075



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
 7075-T7351 2X6.25X7.875
 Issue material from stock: 7075-T7351 (QQ-A-250/12)
 Cut Size 2.0 x 6.25 X 7.88
 Grain Along Long 7.88 Length
 Batch No: B34873 -2

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Program part number and batch number.
 1-Inspect part number and batch number are programmed correctly.
 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
 3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
 4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
 5-Deburr *J.L 08/10/06*

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
 Machine Keyway and inspect per attached dimension sheet *J.L 08/10/06*

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET *J.L 08/10/06*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 23/10/2008 10:54:04 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE

Job Number: 42885

Part Number: D29322UP

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 08/11/07 10

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M.F. 08/11/10

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

8/11/10

SP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 425

8/11/10

(10x)

SP

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/12

Job Completion



MF 08-11-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 42885
Description: 206 Saddle, Outboard, Right side	Part Number: D2932-2
Inspection Dwg: D2932 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.112	.114	.114	.117		
B	0.100	0.140		.113	.113	.114	.117		
C	0.100	0.140		.127	.120	.121	.119		
D	0.210	0.230		.218	.219	.219	.219		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.516	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.120	.120	.121	.120		
O	0.540	0.560		.544	.549	.548	.550		
P	0.490	0.510		.501	.500	.498	.503		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.492	2.492	2.492	2.492		
S	0.240	0.270		.243	.253	.253	.255		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.318	.318	.318	.318		
X	1.125	1.145		1.134	1.134	1.135	1.133		
Y	1.565	1.585		1.579	1.578	1.578	1.577		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: J.L.
Date: 08/11/06

Audited by: J.F.
Date: 08/11/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 42885
Description: 206 Saddle, Outboard, Right side	Part Number: D2932-2
Inspection Dwg: D2932 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140 ✓		.115	.115	.116	.116		
B	0.100	0.140 ✓		.114	.114	.116	.117		
C	0.100	0.140 ✓		.120	.117	.119	.120		
D	0.210	0.230 ✓		.219	.218	.219	.219		
E	1.245	1.255 ✓		1.250	1.250	1.250	1.250		
F	1.245	1.255 ✓		1.250	1.250	1.250	1.250		
G	2.495	2.505 ✓		2.500	2.500	2.500	2.500		
H	0.510	0.515 ✓		.510	.510	.510	.510		
I	1.572	1.582 ✓		1.577	1.577	1.577	1.577		
J	2.495	2.505 ✓		2.500	2.500	2.500	2.500		
K	0.257	0.262 ✓		.258	.258	.258	.258		
L	0.312	0.317 ✓		.314	.314	.314	.314		
M	0.235	0.240 ✓		.238	.238	.238	.238		
N	0.100	0.140 ✓		.120	.119	.120	.121		
O	0.540	0.560 ✓		.549	.548	.547	.549		
P	0.490	0.510 ✓		.498	.498	.500	.499		
Q	3.715	3.725 ✓		3.720	3.720	3.720	3.720		
R	2.470	2.510 ✓		2.492	2.492	2.492	2.492		
S	0.240	0.270 ✓		.253	.255	.255	.253		
T	0.100	0.180 ✓		.140	.140	.140	.140		
U	1.625	1.635 ✓		1.630	1.630	1.630	1.630		
V	1.362	1.372 ✓		1.367	1.367	1.367	1.367		
W	0.316	0.321 ✓		.318	.318	.318	.318		
X	1.125	1.145 ✓		1.133	1.134	1.134	1.134		
Y	1.565	1.585 ✓		1.577	1.577	1.577	1.578		
Z	0.178	0.198 ✓		.188	.188	.188	.188		
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Accept/Reject									

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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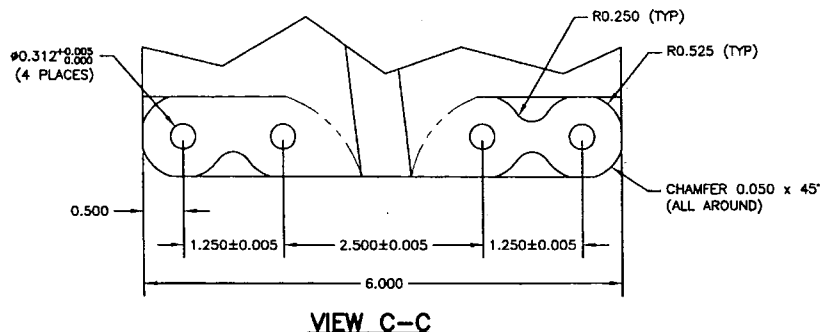
DART AEROSPACE LTD	Work Order: 42885
Description: 206 Saddle, Outboard, Right side	Part Number: D2932-2
Inspection Dwg: D2932 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.116	.115				
B	0.100	0.140		.116	.115				
C	0.100	0.140		.120	.121				
D	0.210	0.230		.218	.218				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.510	.510				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.258	.258				
L	0.312	0.317		.314	.314				
M	0.235	0.240		.238	.238				
N	0.100	0.140		.119	.120				
O	0.540	0.560		.549	.550				
P	0.490	0.510		.498	.500				
Q	3.715	3.725		3.720	3.720				
R	2.470	2.510		2.492	2.492				
S	0.240	0.270		.254	.263				
T	0.100	0.180		.140	.140				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		.318	.318				
X	1.125	1.145		1.134	1.134				
Y	1.565	1.585		1.577	1.578				
Z	0.178	0.198		.188	.188				
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AB									
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AG									
AH									
Accept/Reject									

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Date: 08/11/06	Date: 08/11/07

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D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

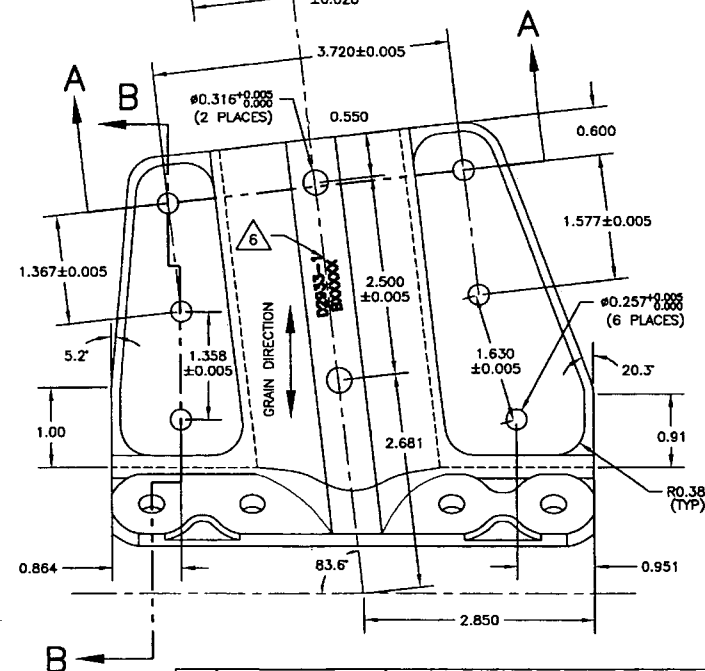
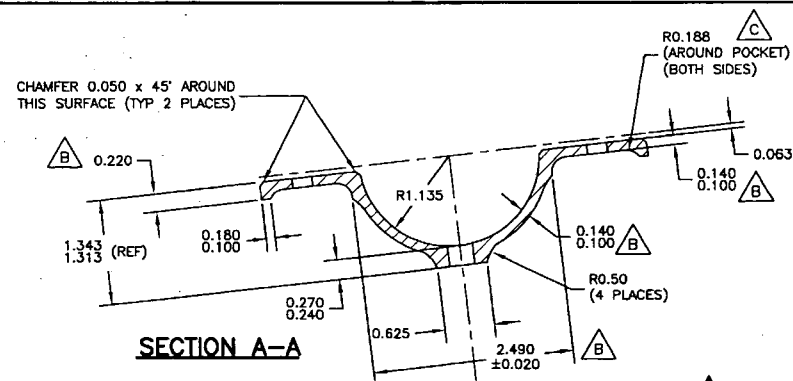
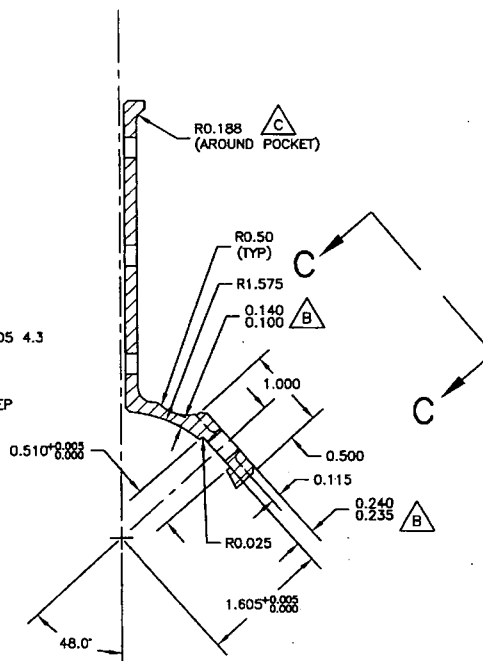
NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
 (MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 42885

RELEASED

07-02-12



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	PH	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE INSIDE
		SCALE
		2.3

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DART DART AEROSPACE USA, INC.
 BELLINGHAM, WA

DRAWING NO. D2933

REV. C
 SHEET 1 OF 1